

Ship Nov 23

Work Order ID 76166

Monday, November 07, 2011 12:58:13 PM

76166

Page 1

Item ID: D3262-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Canister Assembly

Start Date: 11/7/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date: 11-07

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3262	E

100 Weld per dwg A/R Aluminum rod Batch: 18735 0.00

100

Large Fab

Memo

0.00

Large Fab Weld canister assembly as per Dwg D3262 using DT8739 to align fittings

11-11-16 2 f

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

2 Q BE11116

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

S u/w/s

(T)

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

2XPM-11/11/16

140

140

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

2XPM-11/11/16

Memo

****Ensure to mask threads ****

START TIME:

OVEN TEMPERATURE: 320°F

FINISH TIME:

3:20
3:50

150

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 PK 11-11-17-

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Work Order ID 76166

Monday, November 07, 2011 12:58:14 PM

76166

Page 3

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Canister Assembly

Stop

NS2

Start Date: 11/7/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 11/16/2011 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

160

160

Packaging

Packaging

Identify as per dwg & Stock Location:

ST 144

0.00

(2x)

SP 11-11-18

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/11/21 JJ

RHJ/J
(8)

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Picklist Print

Monday, November 07, 2011 12:58:18 PM

Page 1

Work Order ID: 76166

76166

Parent Item: D3262-043

D3262-043

Parent Item Name: Canister Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.01.19 new issue EC verified by: DD
as per ECN10-571 DD 10.05.10 verified :EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3262-1		Manufactured	No			100	Each	0.0000	1	2			
D3262-1 Tube							<u>375196</u>		**			<u>11.11.15</u>	
D3262-5		Manufactured	No			100	Each	5.0000	2	4			
D3262-5 Cap									**			<u>11.11.15</u>	
				<u>Location</u>			<u>Loc Oty</u>			<u>Loc Code</u>			
				LG002			5						
					<u>74724</u>		5						<u>4</u>

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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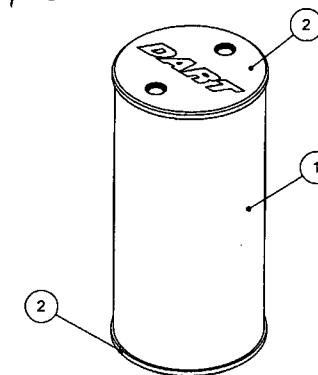
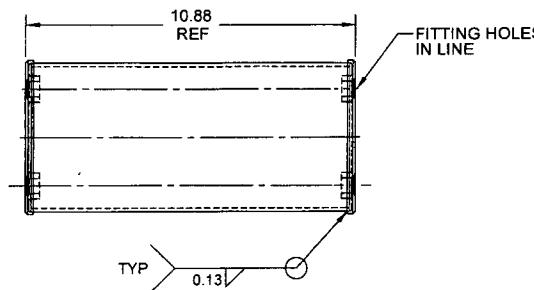
ITEM	QTY 041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

D

D

SHOP COPY
 RETURN TO
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 761664

01/11/07



D3262-041 CANISTER ASSEMBLY

RELEASED
 2010-05-07
M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
 PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3262	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FUEL PURGE CANISTER	NTS
DATE	10.05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS PROVIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN COMMERCIAL OR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

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1

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP

D

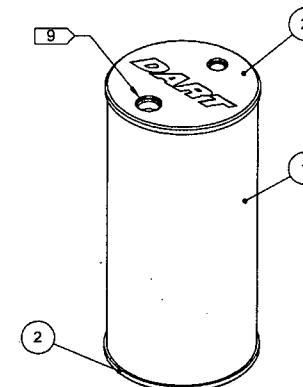
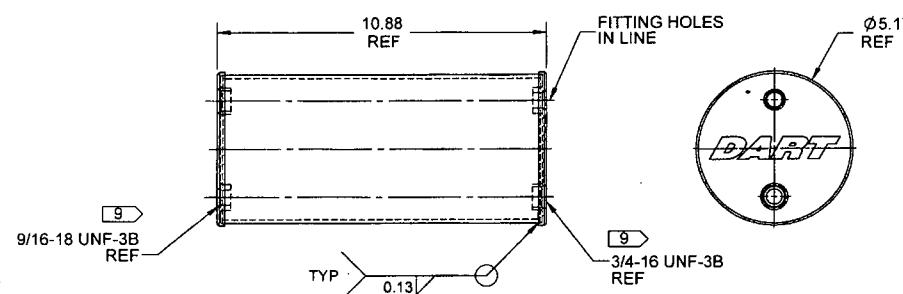
D

C

C

B

B



D3262-043 CANISTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>b</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>b</i>	D3262	SHEET 2 OF 5
APPROVED	<i>b</i>	TITLE	SCALE
DE APPR.	<i>b</i>	FUEL PURGE CANISTER	NTS
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76164

RELEASED
2010-05-07
AM

8

7

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A

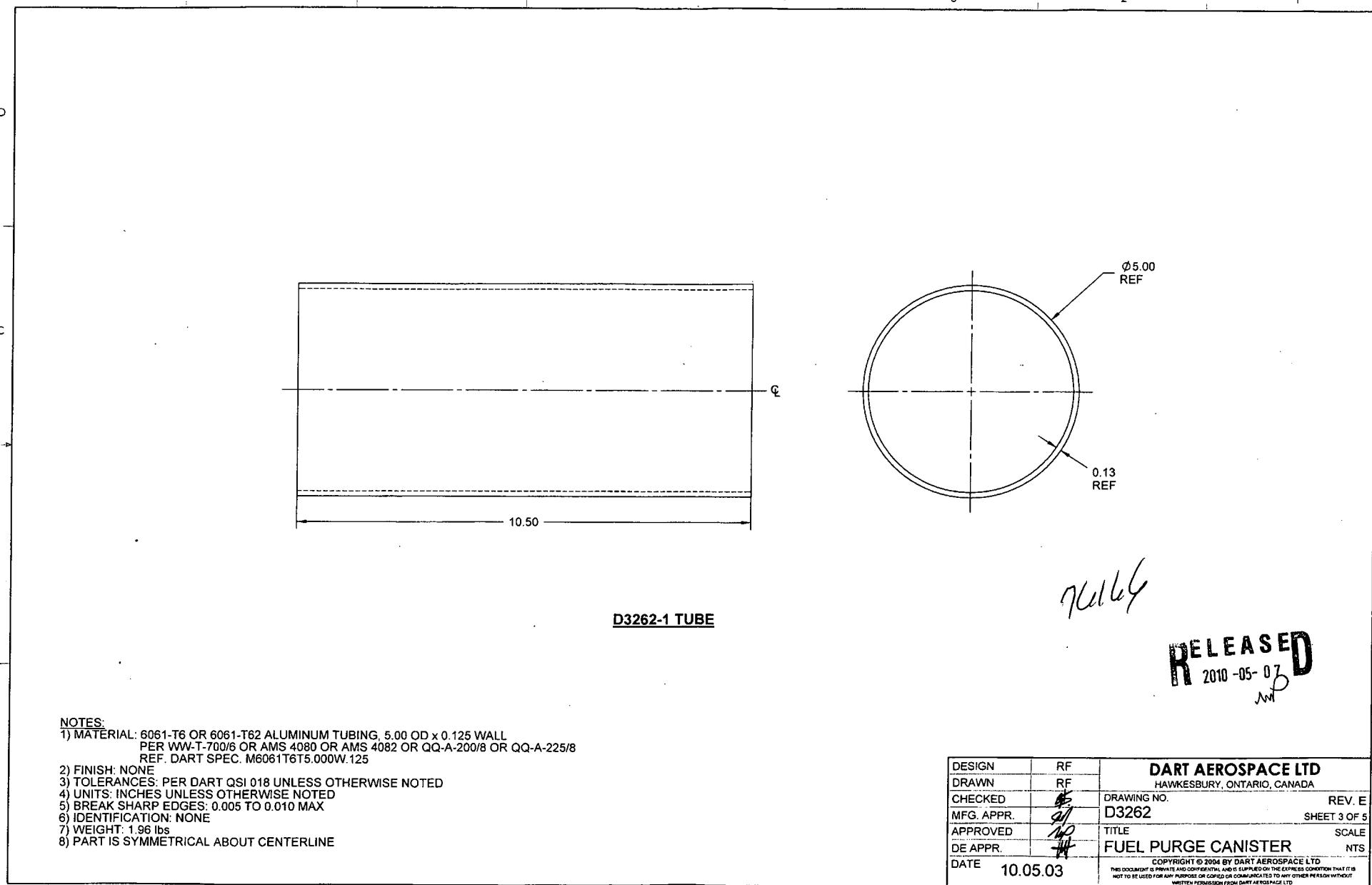
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8 7 6 5 4 3 2 1



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MFG. APPR.	<i>sf</i>	D3262	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

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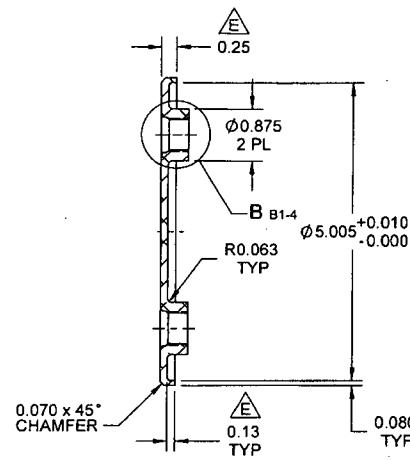
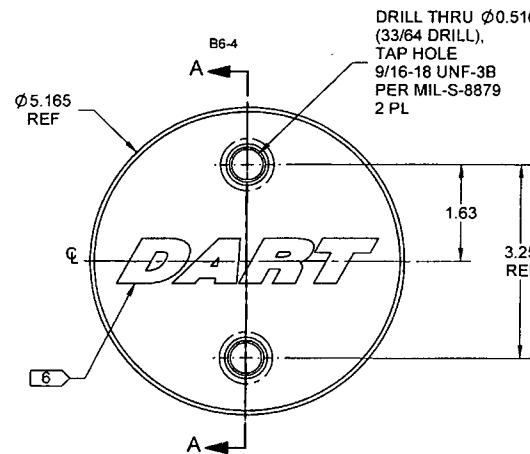
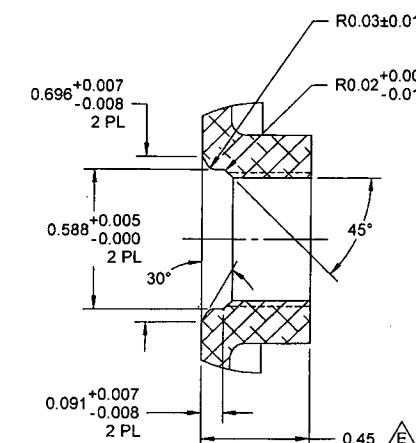
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8 7 6 5 4 3 2 1

D

D

SECTION A-A C5-4D3262-3 CAP7/6/04
RELEASED
2010-05-07
A/N

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

8 7 6 5 4 3 2 1

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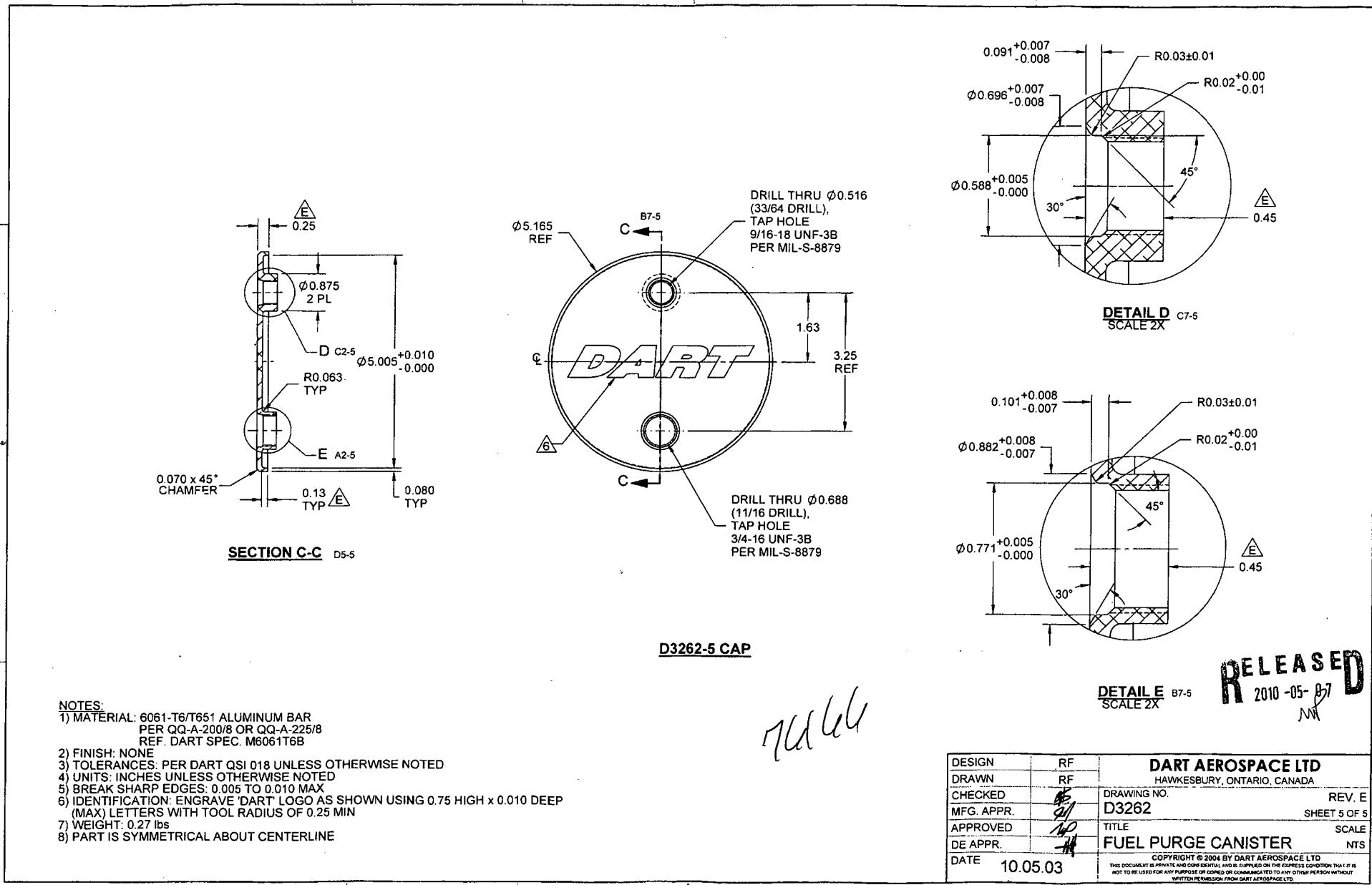
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